

Date: Tuesday, 23/09/2008 11:15:33 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3136-041
Job Number	: 42210		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D3136041
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: R08-084
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : THERMOFORMING	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 29/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08.9.23</u>		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3136041	Window Assembly
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Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)  
 Window Assembly  
 Original B37436

0809.23 (D)

2.0	QC	QUALITY CONTROL
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Comment: QUALITY CONTROL  
 Part is to remain in quarantine, for evaluation.

0809.23

Window to be test fitted by eng upon an assembly, for a fit and function.

(P70)

Work order will then be completed upon the results.

see below.

Job Completion



U 08/10.27

- window's Measurements are IAW WITH  
 Dwg 3136-041

- window appears slightly concave when  
 INSTALLED

0809.24

08/10.27

3.0 QC 21.

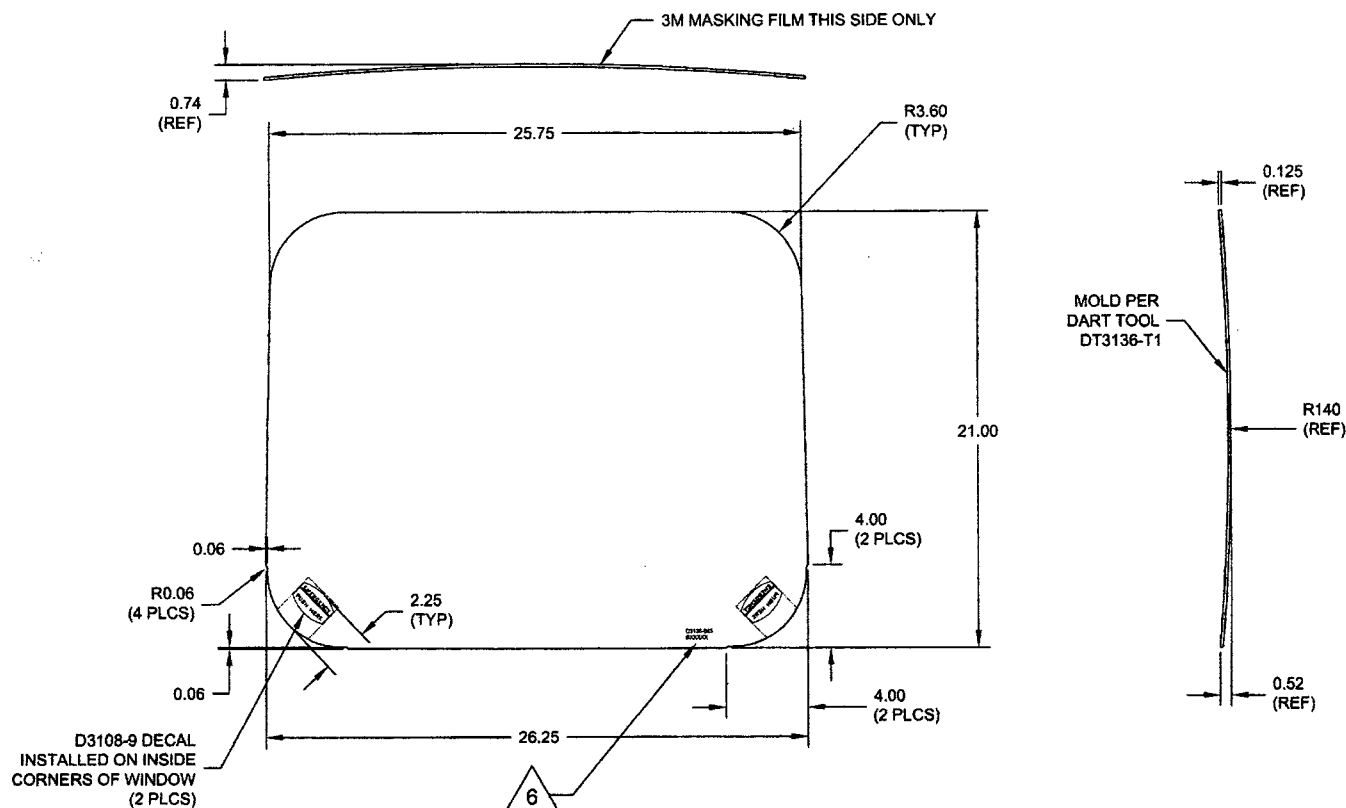
08/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: NIA Fault Category: Prod/Thermforming NCR: Yes No DQA: D Date: 08/10/09  
 (412-694-015, 709-09) Resolution: Scrap Disposition: Scrap QA: N/C Closed: H Date: 08/11/11

NCR: <u>42210</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-20	2.0	Windows is in fact concave upon installation.  R.C: Window is not formed enough, resulting in it pushing itself inwards.	<u>[Signature]</u> 08/10/22	Scrap: destroy the windows.  No other stock is affected. All appear to be properly formed.	<u>[Signature]</u> 08/10/25	<u>[Signature]</u> 08-10-22	<u>[Signature]</u> 08/10/22	<u>[Signature]</u> 08-10-20
		Process						

NOTE: Date & initial all entries









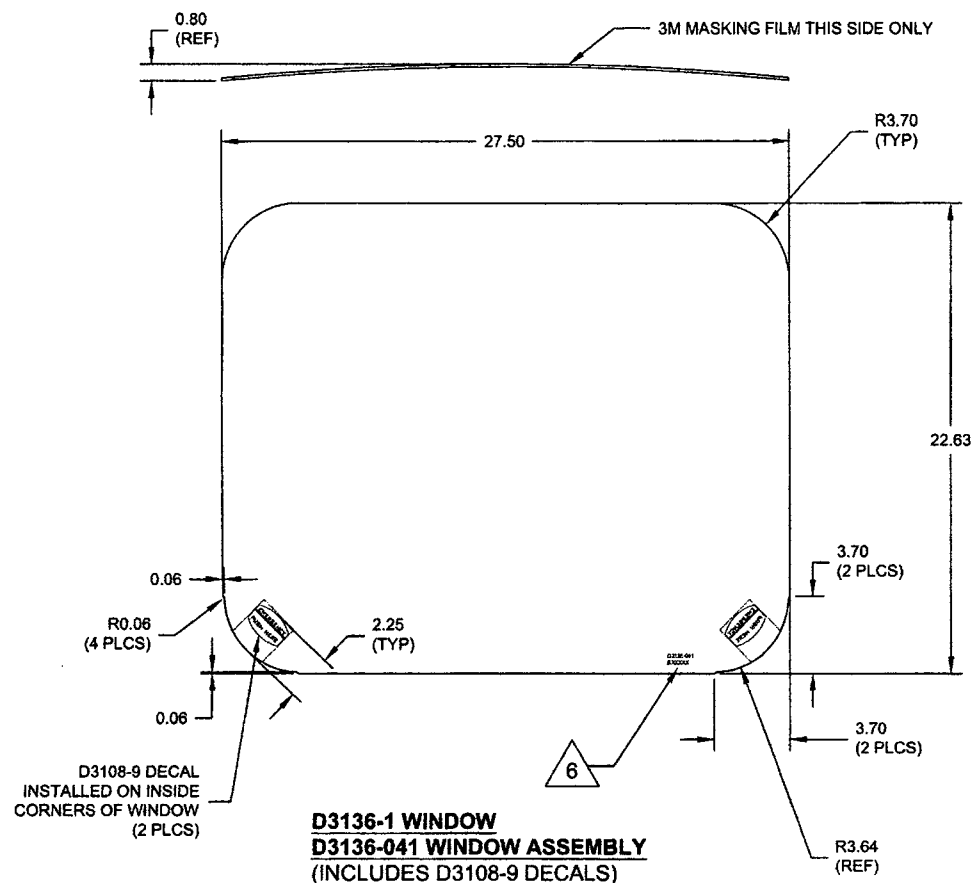
REFERENCE ONLY

**D3136-3 WINDOW**  
**D3136-043 WINDOW ASSEMBLY**  
 (INCLUDES D3108-9 DECALS)

**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G  
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE  
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
 b) DRAPE OVER D3136-T1 MOLD & CLAMP  
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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REFERENCE COPY

RELEASED  
07.09.22

**D3136-1 WINDOW**  
**D3136-041 WINDOW ASSEMBLY**  
**(INCLUDES D3108-9 DECALS)**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G  
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS